

Date: Wednesday, 15/08/2007 3:49:15 PM
User: Linda Lacelle

Process Sheet

Split

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L FLOAT STEP
Job Number	: 33922		
Estimate Number	: 10850		
P.C. Number	: N/A	Part Number	: D206628024
This Issue	: 15/08/2007 S.O. No. : N/A	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: N/A
Previous Run	: 33759	Material	: N/A
Written By	:	Due Date	: 31/08/2007
Checked & Approved By	:	Qty:	1 Um: Each
Comment	: Est Rev:D As Per Ecn 766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-024 CHG 002

Er 21/09/10 @

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

B

3.0	33922A	FLOAT STEP ASSEMBLY RH (206/407)
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Comment: Sub-Component FLOAT STEP ASSEMBLY LH (206/407)

D2842-042 B

B 33922A

B 7/7/10 ①

4.0	D27317	Mounting Lug
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2731-7 Mounting Lug

B 33720

A

5.0	D28441	Arm
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2844-1

Arm

B 33760 2x

A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 3:49:15 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 33922

Part Number: D206628024

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D28443

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2844-3

Arm

B 33198 2X

7.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2660 f(s)/Unit Total: 5.0639 f(s)

Pick:

Qty Part #

Description

Batch

2 D2856-400 6.9" Abrasion Strip

B 332992

8.0

D3394043

LUG ASSY



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D3394-043 LUG ASS,Y

B 30998 14X

9.0

AN3C4A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN3C4A

Bolt

M105143

10.0

AN4C12A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C12A

Bolt

M104937

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 3:49:15 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 33922

Part Number: D206628024

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	AN4C13A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	AN4C13A	Bolt	M105289

12.0	AN4C15A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	AN4C15A	Bolt	M103915

13.0	AN960C10	WASHER
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Comment: Qty.: 3.0000 EACH(s)/Unit Total: 12.0000 EACH(s)
Pick:

Qty	Part Number	Description	Batch
3	AN960C10	WASHER	M101064

14.0	AN960JD416L	Washer
------	-------------	--------



Comment: Qty.: 24.0000 Each(s)/Unit Total: 96.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
24	AN960JD416L	Washer	M105072 M105408

15.0	NAS1515H4L	WASHER
------	------------	--------



Comment: Qty.: 24.0000 Each(s)/Unit Total: 96.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
24	NAS1515H4L	Washer	M105143 45 X M105211 51 X

16.0	MS210434	Nut
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Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
12	MS21043-4	Nut (or MS21042-4)	M105115

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/09/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 3:49:15 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 33922

Part Number: D206628024

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

NAS1515H3

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 NAS1515H3 Washer

m105164

PU 7/9/10 (4)

18.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

En 07/09/10

CU

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-024

Location:

PPP Rev:

f

07/9/10

(1)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/10

Job Completion



U 07/09/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPUT 628.024

Dart Aerospace Ltd.







Date: Wednesday, 15/08/2007 3:49:28 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOAT STEP ASSEMBLY RH (206/407)
Job Number : 33922A -2	
Estimate Number : 11775	
P.O. Number : N/A	Part Number : D2842042
This Issue : 15/08/2007 S.O. No. : N/A	Drawing Number : D2842 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : B
Previous Run : 33759A	Material : N/A
Type : LARGE FAB ASSY	Due Date : 31/08/2007
Written By : _____	Qty: 4 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:D As Per Ecn 766 06-01-06 JLM	

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	D2622120C	Extrusion
<div></div>		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)		
Qty	Part #	Description Batch:
1	D2622-120C	Extrusion 332858
Check Material for any Dents or Defects		
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
<div></div>		
Comment: LARGE FABRICATION RESOURCE 1		
1-Cut D2842-1 using D2622 extrusion as per Dwg D2842 a.m 07.08.29		
2-Drill D2842-1 using Jig DT8272 as per Dwg D2842 a.m 07.08.29		
3-Deburr and bevel ends for welding a.m 07.08.29 4		
3.0	D2734	206 Step Endplate
<div></div>		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)		
206 Step Endplate		
Pick:		
Qty	Part Number	Description Batch
2	D2734	End Cap 330883
K.E. 07.08.30		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 3:49:28 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 33922A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D34591

plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

plate

Batch: B 33807

KE 07.08.30 4

5.0

D34593

plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

plate

Batch: B 33226

KE 07.08.30 4

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs as per Dwg D2842

A/R AL Rod Batch: M103794
M104721

2-Grind end cap weld flush

KE 07.09.04 4

A.M 07.09.04

7.0

~~DO NOT USE~~

QC#5/QC#9

WELD INSPECTION



Comment: WELD INSPECTION

QC#5 En 07/09/04 (4)

QC#9 07/09/04 (4)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

A.M 07.09.04 4

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 07/09/05 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 3:49:28 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 33922A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description:

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding. *a.m. 07.09.05*

Weld end cap as per Dwg D2842.

A/R AL Rod Batch: *M103794*

2-Grind end cap weld flush. *a.m. 07.09.06*

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0

NAS1329C3KB130

insert



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Insert

Pick:

Qty Part Number

Description Batch

3 NAS1329C3KB130Insert

M104474

16.0

MS27039C107

screw



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 MS27039C1-07

Screw

M104936

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/09/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 3:49:28 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 33922A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

NAS1515H3L

WASHER



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

3 NAS1515H3L

WASHER

M104603

m.k

18.0

AN960C10L

washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN960C10L

WASHER

M105143

m.k

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: FINISHING 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch:

M105386

F2/m.k

m.k 07/09/07

(4X)

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 06/06/07

(4RH)

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 33922

07/09/10

(1)

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/10

Job Completion



W 07/09/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

40
339224



NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

Technical drawing of a D2734 end plate. The drawing shows a horizontal section of a pipe with a wavy line on the left indicating a break. The end plate is attached to the right end of the pipe. A dimension line indicates a vertical offset of 1.000 from the horizontal centerline to the top edge of the end plate. A dimension line indicates a 45.0 degree angle for the bend of the end plate. A label 'MATCH BEND RADIUS OF END PLATE' points to the curved transition between the pipe and the end plate. A label 'D2734 END PLATE' points to the end plate itself.

RELEASED
05-11-14
df

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Customer : CC-DAR01 Dart Aerospace Ltd.

Drawing Name : D206-628-024

Job Number : 37229

Estimate Number : 10804

P.O. Number :

This Issue : 05/02/2008 S.O. No. :

Prsht-Rev. : NC

First Issue : 11 Type : LARGE FAB ASSY

Previous Run : 37228

Part Number : D206628024

Drawing Number : ECN 1118

Project Number :

Drawing Revision :

Material :

Due Date : 12/02/2008

Qty: 5 Um: Each

Written By : Checked & Approved By : 

Comment :

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
PULL FROM STOCK

D206-628-024 CHG002 1x B33759

3x B34576

2. 33922 003

B34576 3x

2.0 PACKAGING 1 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
ADD NEW PARTS TO KIT PER ECN 1118*** NEW RED AND WHITE LABELS REQUIRED FOR
NEW CHANGE NUMBER ***

8x D2732 RUBBER EXTRUSION

CUT 3.00" LONG B

34717

B34717

4x AN4C14A BOLT B

107087

M107087

4x AN4C15A BOLT B

106785

M107013

8/2/12

50

(5x)

3.0 D2732 Rubber Extrusion

Comment: Qty.: 2.0000 f(s)/Unit Total: 10.0000 f(s)
Rubber Extrusion

B34717

8/2/12

50

(5x)